

SPUT

Dart Aerospace Ltd.

Date: Thursday, 24/07/2008 8:21:26 AM
User: Melanie Fauteux

Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40607
Estimate Number : 13436
P.O. Number :
This Issue : 24/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/07/2008 Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : MF 08-07-24
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY
Part Number : PB674300113
Drawing Number : B6743001 P.8
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 24/07/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001255	Inner Tube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 40541	
2.0	PB6743001249	Inner Tube Bushing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: mi2141	
3.0	PB6743001253	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340717	
4.0	PB6743001254	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340053	
5.0	PB674300167	PB67-43001-67
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-67 batch: 340243	

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Part Number: PB674300113

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

Handwritten: 08-07-29.5

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-07-29.5

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/07/29

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
HELICAL INSERT

Handwritten: M 17935

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helicol
- 3- install helicol insert as per dwg

Handwritten: 08-07-31

Handwritten: 5

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/07/31

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08-07-31

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Handwritten: 08/07/31

Handwritten: SX

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Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320
2:10

M-L 08/07/31

(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/31

(5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

90 Degree Cover Plate

batch: 340069

PH 08-08-26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

PH 08-08-26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: M108926

PH 08-08-26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: M108473

PH 08-08-26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

PH 08-08-26

3

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Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslovskiy

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *509*

8/9/12

(xa) SP

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



MF 08-09-12



